

Work Order ID 67584

Page 1

Monday, March 28, 2011 11:40:55 AM

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Item Name: Support Assembly

36

Stop



Start Date: 3/28/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

H

Date: 11/03/28 Tooling:

Date:

Run Start



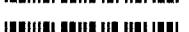
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3278	Rev C

100

 Small Fab
 Small Fab
 Memo
 Rivet spacers with support as per Dwg D3278.

EP 11/03/31 (36)

110

 QC
 Quality Control
 Memo
 QC5- Inspect part completeness to step on W/O

0.00
 S w/05/31

0.00
 (36)

120

 Small Fab
 Small Fab
 Memo
 Assemble support as per Dwg D3278. ***DO NOT TIGHTEN
 BOLTS*** Identify as D3278-041

EP 11/04/12 (36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3278-041

Accept



Setup

Start



Revision ID:

Item Name: Support Assembly

Stop



Start Date: 3/28/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Packaging

Packaging

Identify as per dwg & Stock Location: ST471

0.00

0.00

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

MF 11/04/14 36

11/04/14 JJ

*MF
11-04-14*

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NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 11:41:01 AM

Page 1

Work Order ID: 67584



Parent Item: D3278-041



Parent Item Name: Support Assembly

Start Date: 3/28/2011

Required Date: 3/31/2011

Comments: IPP: 04.04.19 New issue KJ/JLM
 IPP: B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Start Qty: 40.00

Start Qty: 40.00

Required Qty: 40.00

Required Qty: 40.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

Monday, March 28, 2011 11:41:01 AM

Work Order ID: 67584



Parent Item: D3278-041



Parent Item Name: Support Assembly

Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 40.00

Required Qty: 40.00

AN4-13A



Purchased

No

120

Each

338.0000

2

80



EP 11/04/12

Bolt

Location

ST357

Loc Qty

338

Loc Code

AN960JD416



NAS1149D0463J Purchased

No

ST357

116786

38

117094

300

120

Each

0.0000

4

160



M117313

19x

Washer

D2230-1



Manufactured

No

ST476

65270

120

Each

20.0000

2

80



Lug

Location

ST476

Loc Qty

20

Loc Code

MS20426AD3-6



Purchased

No

ST476

65270

120

Each

4,093.000

4

160



B67396

35x

Rivet

Location

ST316

Loc Qty

4093

Loc Code

105055

523

116289

3570

144

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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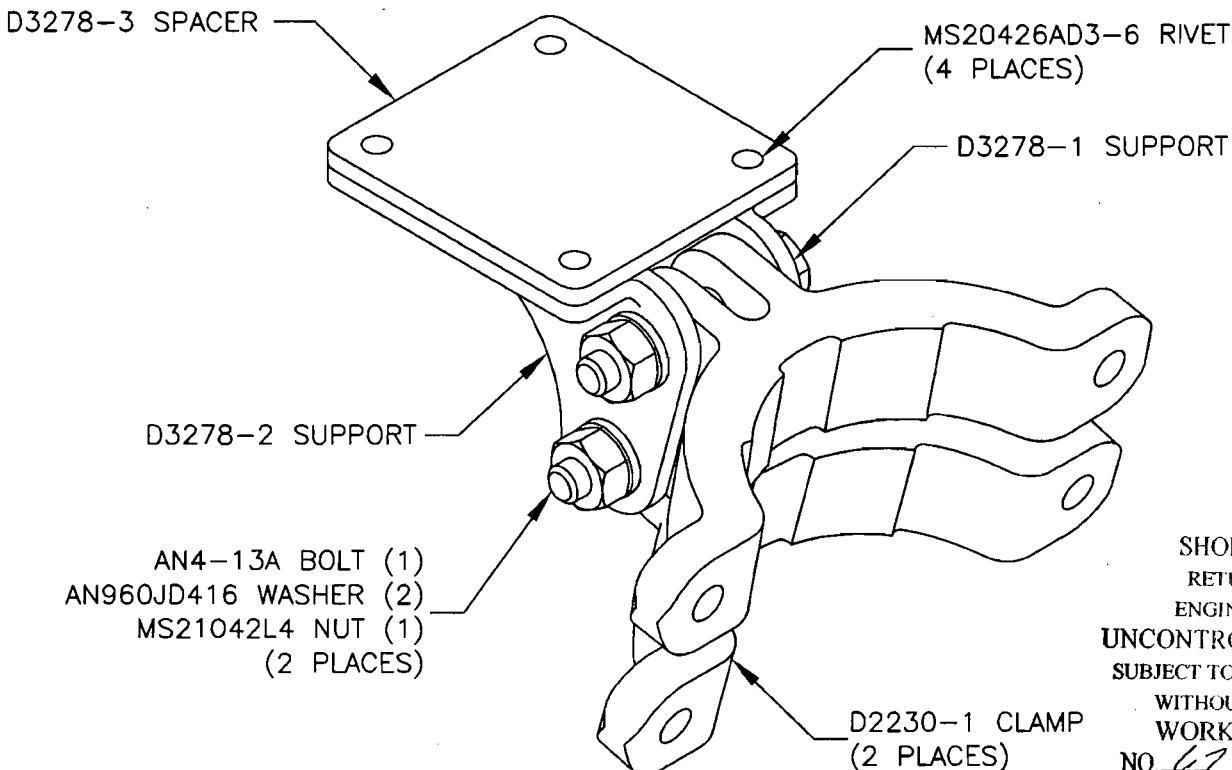
NOTE: Date & initial all entries

DART

DESIGN <i>9P</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>dt</i>	DRAWING NO. D3278	REV. C	SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS	
A	04.03.03	NEW ISSUE		
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT		
C	07.07.24	CHANGED RIVETS PER PAR #185		

RELEASED
07.08.08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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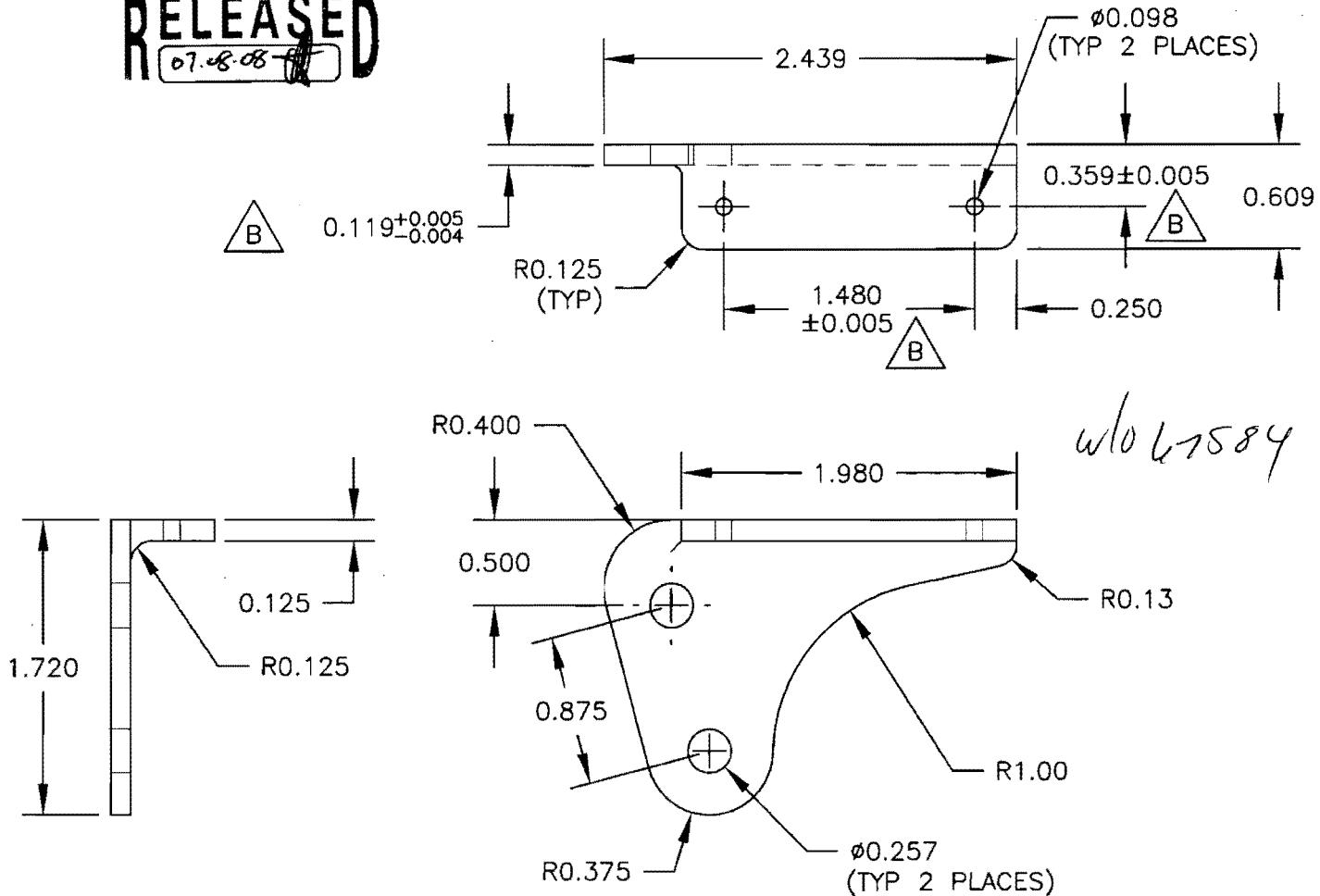
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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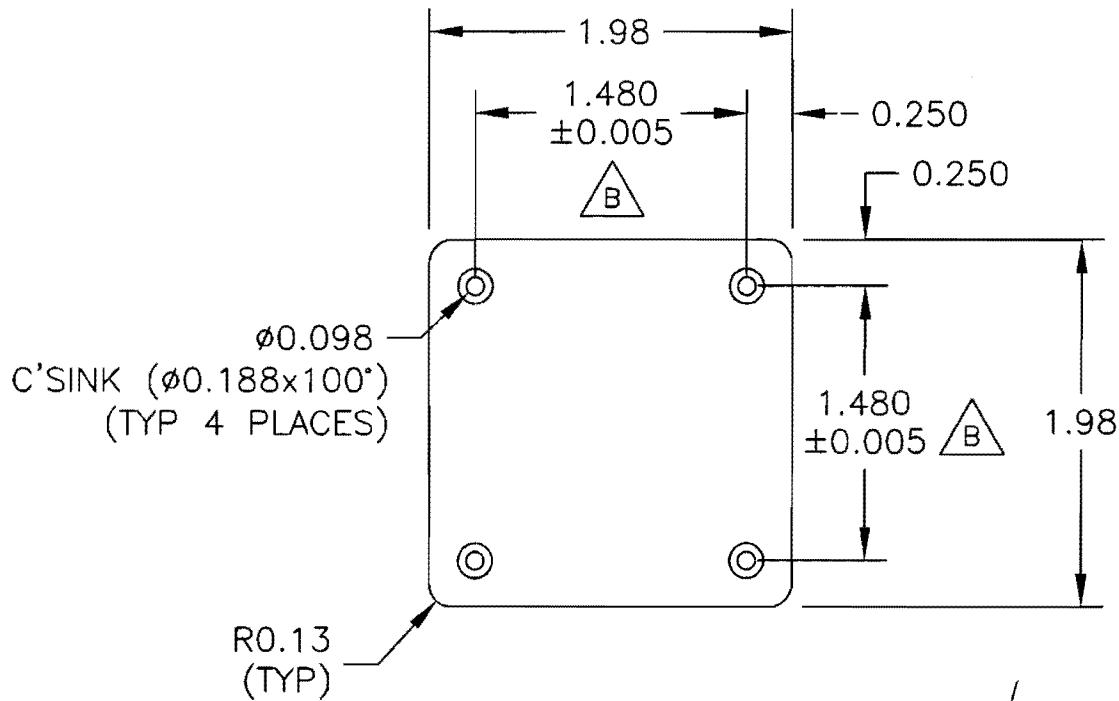
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>BS</i>	APPROVED <i>HF</i>	DRAWING NO. D3278	REV. C	SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1	

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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